

Work Order ID 128354

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128354

ASAP

Page 1

Item ID: D3021-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tube Assembly
 Start Date: 1/16/15 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 1/23/15 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-01-16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3021	B								

100 0.00
 100 Large Fab
 Large Fab Memo 0.00
 Large Fab 1-Cut tube as per Dwg D3021
 2-Drill tube as per Dwg D3021 using DT8622
 3-Deburr
 4-Weld stud and end cap as per Dwg D3021 QSI004
 A/R 4130 Rod Batch: M12725

6 2 15-1-28

110 0.00
 110 QC Memo 0.00
 Quality Control

6 15-01-25 PD

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Item ID: D3021-043 Accept *N900040100* Setup Start *NS1*
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Start Date: 1/16/15 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 1/23/15 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				6	0		
120									
QC	Memo	0.00							
Quality Control									15/01/29 PD DAS 49 9-89
130	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3	0.00				6	0	1525	
130									
Powdercoat	Memo	0.00							
Powder Coating	*** MASK THREAD PRIOR TO POWDERCOAT*** START TIME: 2:20 OVEN TEMPERATURE: 370° FINISH TIME: 2:50								
140	QC3- Inspect Part Finish	0.00				6			
140									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 FEB 06 2015

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Item ID: D3021-043 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Tube Assembly
 Start Date: 1/16/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 1/23/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>St223B</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

6 15-02-09
 FEB 09 2015
 MF
 15-2-9

Picklist Print

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Work Order ID: 128354

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Parent Item: D3021-043

D3021-043

Parent Item Name: Tube Assembly

Start Date: 1/16/15

Required Date: 1/23/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.06.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3017-11 Manufactured No

100 Each 34.0000 1 6

D3017-11

Cap

EL 15-1-21

Location

Loc Qty

Loc Code

WA001

34

116790

34

D4667-041 Manufactured No

100 Each 0.0000 1 6

D4667-041

Armrest Stud Assembly

EL 15-1-28

128053X6

M4130NT0.750W.049 Purchased No

100 f 103.2160 2.325 15

M4130NT0 750W 049

4130 RD Tube .750 x.049W

EL 15-1-20

Location

Loc Qty

Loc Code

MAT033

103.216

m122425

22.5

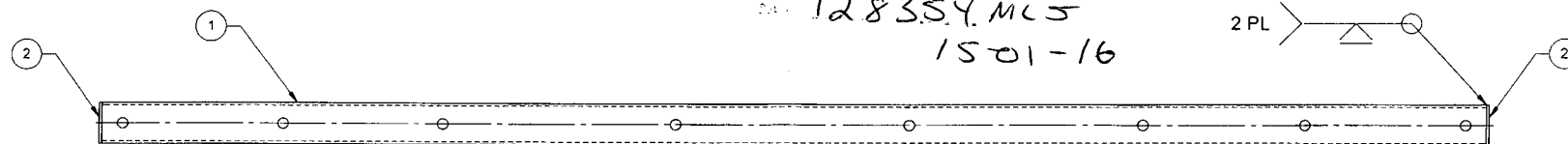
m130619

80.716

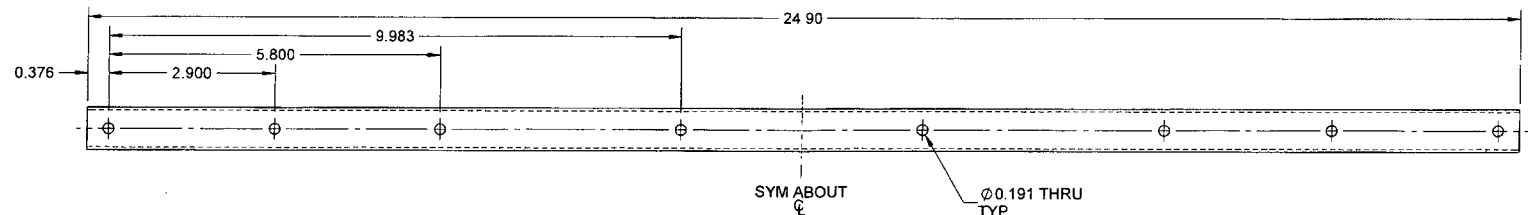
15-2

ITEM	QTY	P/N	DESCRIPTION
	X	D3021-041	TUBE ASSEMBLY
1	1	D3021-1	TUBE
2	2	D3017-11	END CAP

SUPPLY
 PART NO.
 128354 MCL5
 1501-16



D3021-041 TUBE ASSEMBLY



D3021-1 TUBE

NOTES:

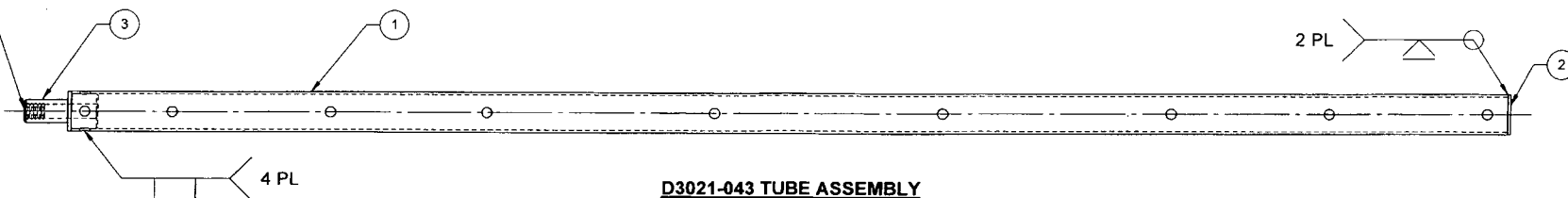
- MATERIAL -041: N/A
-1: AISI 4130N SEAMLESS STEEL TUBING, $\phi 0.750 \times 0.049$ WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF M4130NT0.750W.049
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: IDENTIFY WITH DART P/N "D3021-041" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- WEIGHT: 0.77 lbs

RELEASED
 2012-07-03
 P. 12-616

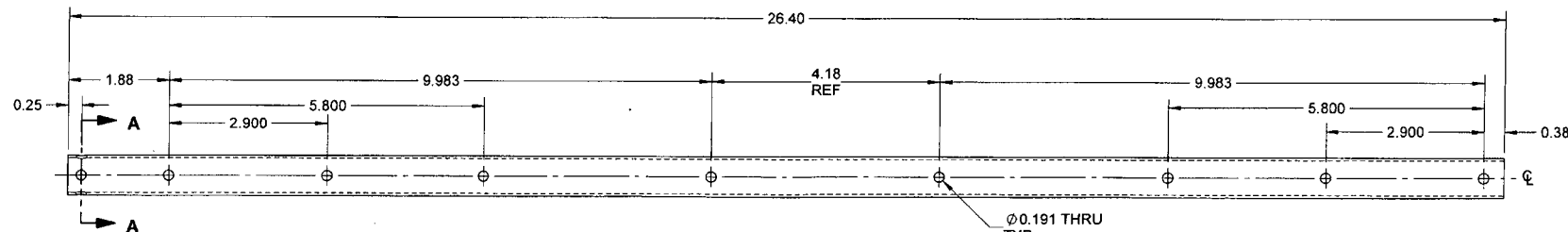
B	REFORMAT, ADDED -043 & -3	AJS	12.06.12
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. B
CHECKED	CP	D3021	SHEET 1 OF 2
MFG. APPR.	CP	TITLE	SCALE
APPROVED	CP	TUBE ASSEMBLY	NTS
DE APPR.	CP	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.06.12		

ITEM	QTY	P/N	DESCRIPTION
	X	D3021-043	TUBE ASSEMBLY
1	1	D3021-3	TUBE
2	1	D3017-11	END CAP
3	1	D4667-041	ARMREST STUD ASSY

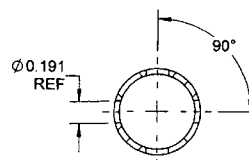
MASK THREAD PRIOR
TO POWDER COAT



D3021-043 TUBE ASSEMBLY



D3021-3 TUBE



NOTES:

- 1) MATERIAL -043: N/A
-3: AISI 4130N SEAMLESS STEEL TUBING, Ø0.750 X 0.049 WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF M4130NT0.750W.049
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3021-043" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.88 lbs

SECTION A-A

SCALE 1:2

2012-07-09

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3021	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		TUBE ASSEMBLY	NTS
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